

Work Order ID 62378

September 29, 2010 7:45:09 AM



Page 1

Item ID: D2873-045

Accept



Setup Start



Revision ID:

Stop



Item Name: Nut Plate Assembly

Start Date: 9/29/10 Start Qty: 20.00



Cust Item ID:

Required Date: 10/15/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 10/9/29 Tooling: _____

Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2873	Rev A
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100

0.00



BAND SAW

Bandsaw

Memo

0.00

M.A 10/10/06

20 0

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 2.700" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-5
Dwg Rev A F1819 Folio Rev AA

SL 10/10/07



120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/10/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							
				5/10/10/07		20	0		
140 Small Fab Small Fab Small Fab	Small Fab Memo 1-Deburr □2- C'sink as per Dwg D2873	0.00 0.00							
									5/10/10/07 (20)
150 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
				5/10/10/08		Count 20			

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-10-12



HandFinish

Memo

0.00

20

Hand Finishing

170

QC3- Inspect Part Finish

0.00

=> HL 10/10/12



QC

Memo

0.00

20

Quality Control

180

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 □2-Identify as D2873-045

ES 10/10/12 20

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

SB 10/10/19

Quality Control

200

Identify as per dwg & Stock Location: X-tubes

0.00



Packaging

Memo

0.00

MA 10 10 25 (20)

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/10/25

Quality Control

MA 10-10-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

September 29, 2010 7:45:09 AM

Page 1

Work Order ID: 62378



Parent Item: D2873-045



Parent Item Name: Nut Plate Assembly

Start Date: 9/29/10

Required Date: 10/15/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.375X01.00 0		Purchased	No			180	f	38.9225	0.225	4.736842			



6061T6 BAR .375 x 1.00

Location	Loc Qty	Loc Code
MAT01	0.45	
113325	0.45	
MAT04	38.4725	
✓114352	38.4725	

MS20426AD4-6

Purchased

No

180

Each

2,849.000

4

80



Rivet

Location	Loc Qty	Loc Code
ST317	2849	
110139	2849	

MS21075L5

Purchased

No

100

Each

33.0000

2

40



Nut Plate

Location	Loc Qty	Loc Code
ST350	33	
115438	33	

4.7368^{tr} M.A 10/10/06

EP 10/10/19

80

EP 10/10/19

35

M115908 (500)

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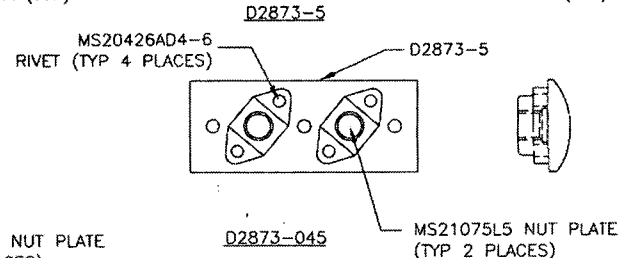
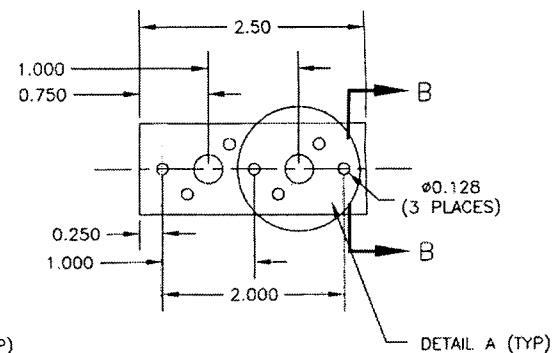
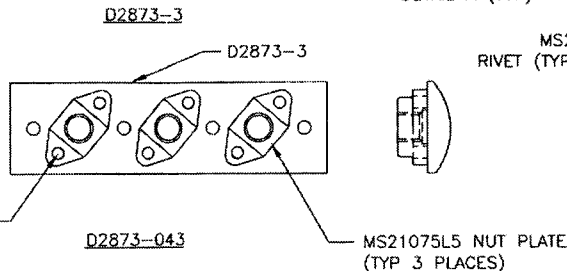
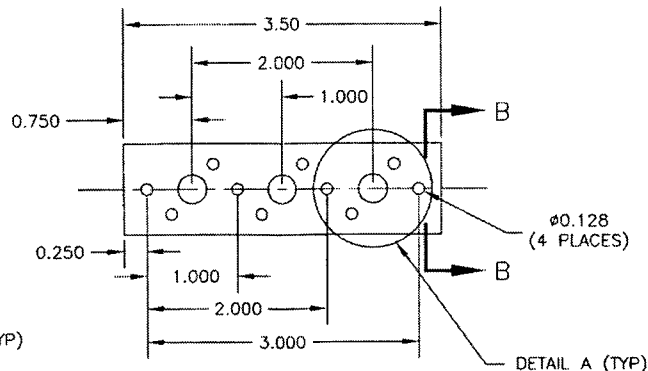
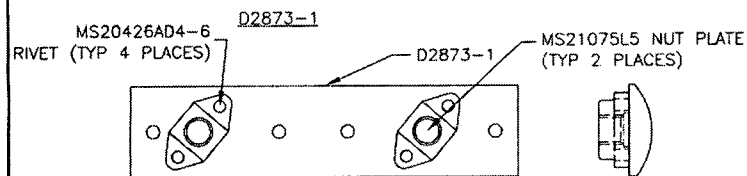
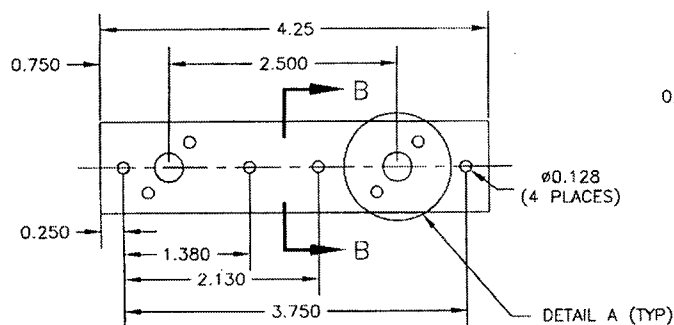
W/O:		WORK ORDER CHANGES					
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D2873-1/-3/-5 RADIUS BLOCK

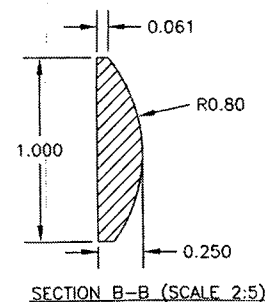
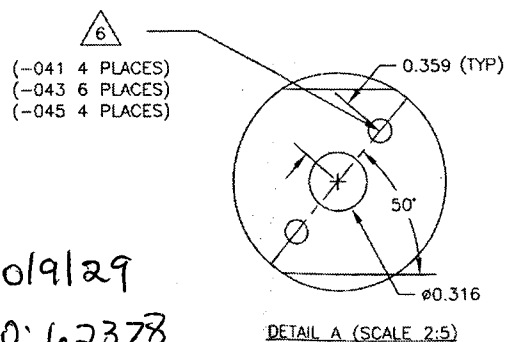
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
105.07.26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD MISSISSAUGA, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873 REV. A SHEET 1 OF 1
DATE 05.07.26	TITLE RADIUS BLOCK	SCALE 4:5